

Date: Thursday, 12/10/2006 11:46:04 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: NUT PLATE
Job Number	: 28935	Part Number	: D2680041
Estimate Number	: 10316	Drawing Number	: D2680 REV B1
P.O. Number	: <i>N/A</i>	Project Number	: N/A
This Issue	: 12/10/2006 S.O. No. : <i>N/A</i>	Drawing Revision	: B1
Prsht Rev.	: NC	Material	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Due Date	: 30/10/2006
Previous Run	: 28935	Qty:	50 Um: Each
Written By	: <i>[Signature]</i>		
Checked & Approved By	: _____		
Comment	: Est: D 04.10.01 Added Steps 2-4, 7-8 KJ/JLM Est Rev:E Now on WaterJet 06-10-12 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S16GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.0138 sf(s)/Unit Total: 0.6878 sf(s)
1010/1025/A21/6aA SHEET .063" thk
Batch: *1119131*

ml 06 12 04

(50)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D2680
Dwg Rev: *B1*
Prog Rev: *B1*

ml 06 12 04

(50)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06 12 04

(50)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

11/06/12/04 (50)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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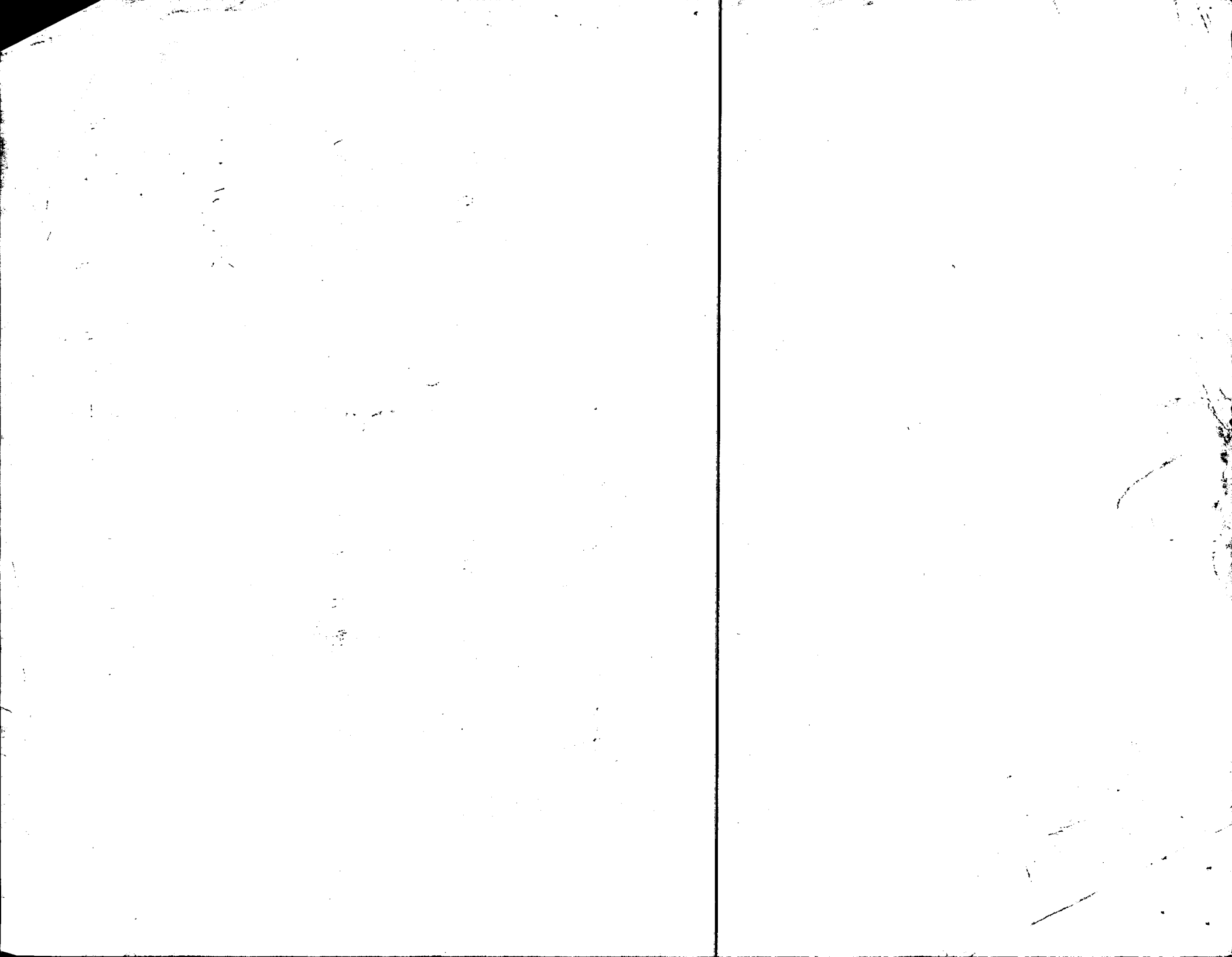


Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Deburr
2-C'sink as per Dwg D2680

50 06 12 04

ml 06/12/22 ml 07/01/08

(50)



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE

Job Number: 28935

Part Number: D2680041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M102391



(50x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m. 2 / m

07/01/11

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(50)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m 01 01 11

8.0

MS20426AD33

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty

Part Number Description Batch

2

MS20426AD3-3

Rivet

M 7681

ml

9.0

MS21069L4

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty

Part Number Description Batch

1

MS21069L4

Nut Plate

M 5865

ml

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plate as per Dwg D2680

ml 07/01/22

(x50)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 07/01/22 (50)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5155

07/01/22 (50)

07/01/12 (50)

07/01/12

Date: Thursday, 12/10/2006 11:46:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE

Job Number: 28935

Part Number: D2680041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

50
P876.123

Job Completion



UL 87401.23

Date: Wednesday, 10/11/2006 12:49:49 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: NUT PLATE
Job Number	: 28935		
Estimate Number	: 10316		
P.O. Number	:	Part Number	: D2680041
This Issue	: 10/11/2006 S.O. No. :	Drawing Number	: D2680 REV B1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : PURCHASED PARTS	Drawing Revision	: B1
Previous Run	: 24203	Material	:
Written By	: <u> </u>	Due Date	: 10/30/2006 Qty: 50 Um: Each
Checked & Approved By	: <u> </u>		
Comment	: Est: D 04.10.04 Added Steps 2-4, 7-8 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: _____

1-Email or Ship DXF file to vendor

2-Laser Cut flat pattern as per Dwg D2680

3- Possible Supplier: GFI or Industrial Laser

4-Material release note is required

M10105166A
.013 SF.

2.0	D26801F	NUTPLATE FLAT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Nut Plate

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr

2-C'sink as per Dwg D2680

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 12:49:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE

Job Number: 28935

Part Number: D2680041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0	MS20426AD33	Rivet
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS20426AD3-3	Rivet	

9.0	MS21069L4	Nutplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21069L4	Nut Plate	

10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plate as per Dwg D2680

11.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

12.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 12:49:50 PM
User: Kim Johnston

Process Sheet

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Drawing Name: NUT PLATE

Job Number: 28935

Part Number: D2680041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

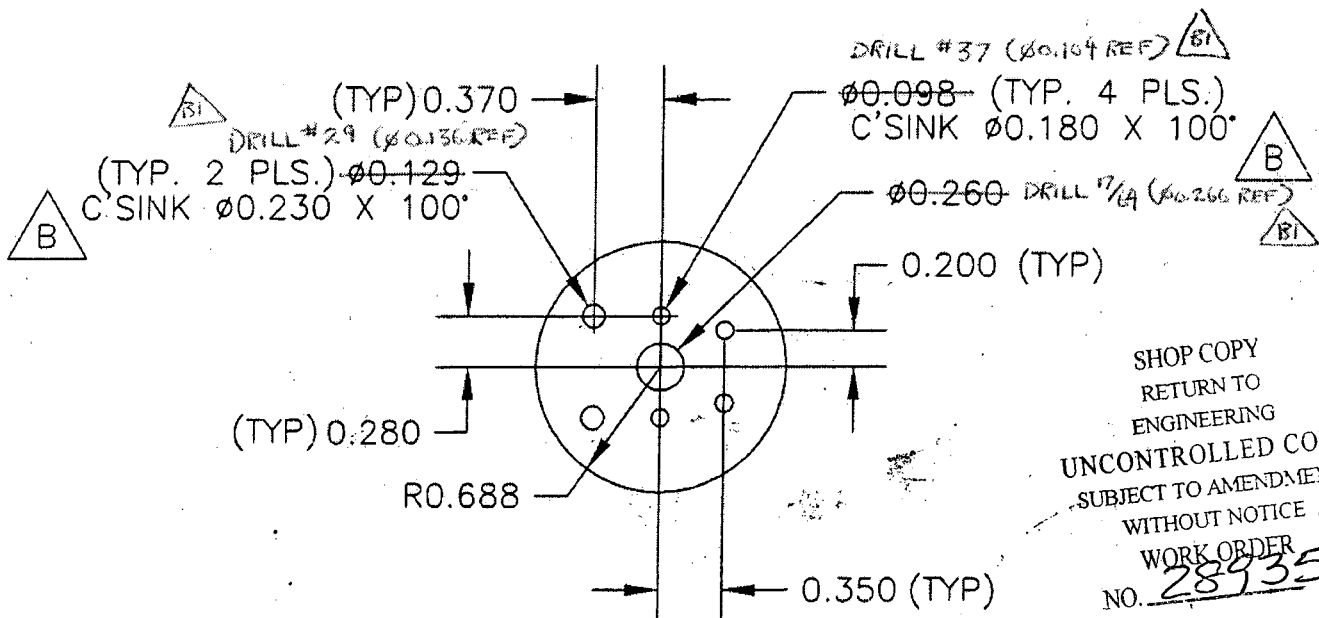
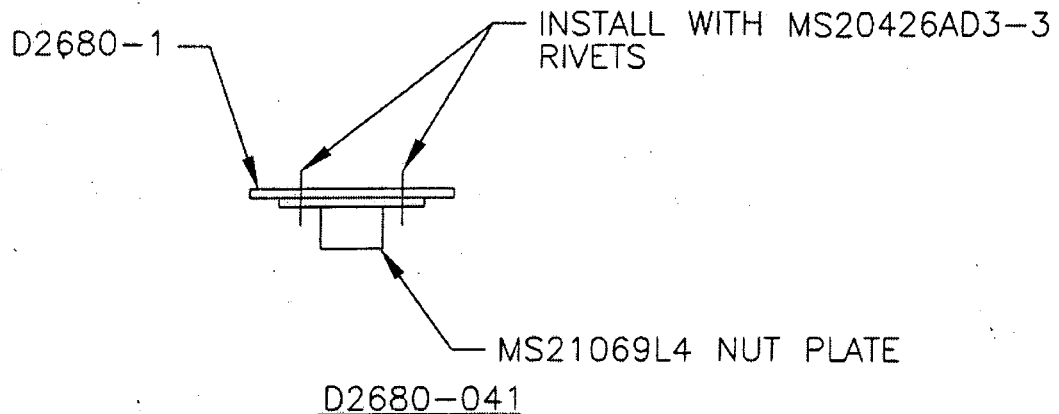
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED CP	APPROVED KE	DRAWING NO. D2680	REV. B SHEET 1 OF 1
DATE 98.12.14	TITLE NUT PLATE		SCALE 1:1
A	97.09.15	NEW ISSUE	
B	98.12.14	CHANGE C'SINKS (PER TSR A1041)	
B1	CP-# 04.11.04	CHANGE HOLES & FINISH	

RELEASED
98.12.14 DS



MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.063 THICK (16 GAUGE)

CAD PLATE PRIOR TO INSTALLATION OF MS21069L4

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

$\triangle B1$ POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
D2680-1

